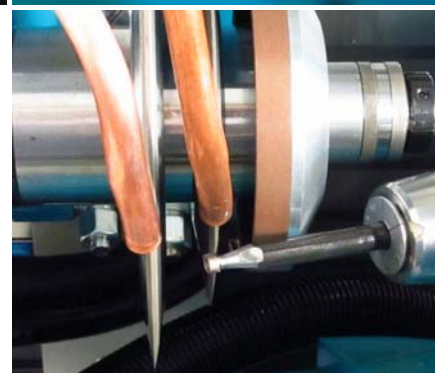
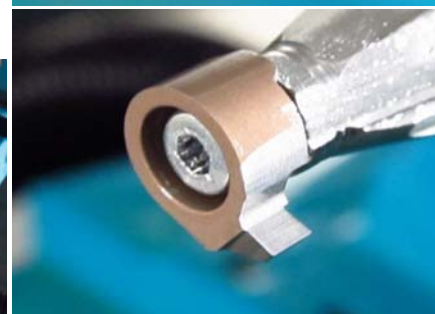









Grooving Insert Ø9.6 Z1

A08-250

The special grooving insert is ground in one setup. The probe operation measures the cutting edge position of the sintered blank. The grooving profile is ground with 2 wheels, used for a pregrinding and a finishing process. The chipbreaker operation has been ground with a wheel of diameter 125 mm. For automatic loading the insert is clamped with adapted TTC-clamping. The chipbreaker is designed with defined convex and concave radii at the bottom ending with defined angle into the outerdiameter.



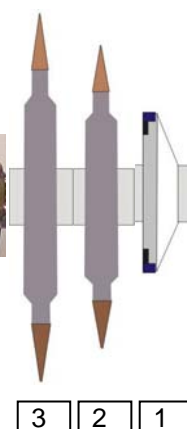
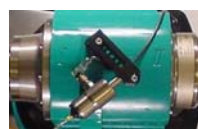
1. Cycletime for Production

Workpiece: special blank 3.9x9.6 Material CARBIDE				
Operations				
Feed [mm/Min]	2000	100	20	50
Power [kW]		1	1	1
Cutting speed [m/s]		22	22	22
Used wheels				
Grinding time [s]	10	35	46	21
Total cycle time	1 Min 52			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	12A2 Ø125 D64
2	14EE1 Ø200 D76V20°
3	14EE1 Ø250 D46V20°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Control: Fanuc 310i

Accessories: TTC Clamping, Robot

Responsible engineer: OP, 27.12.11

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, UK, China

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5